

Work Order ID 68599

Monday, April 18, 2011 12:29:37 PM



Page 1

Item ID: D3245-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 4/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-04-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3245	Rev B

100	Pick Kit	0.00
-----	----------	------



Packaging

Memo

0.00

Packaging

11/04/18 (6)

110	Small Fab	0.00
-----	-----------	------



Small Fab

Memo

0.00

Small Fab

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245 be careful when countersinking...mat'l very thin

11/04/27 (6)

120	QC5- Inspect part completeness to step on W/O	0.00
-----	-----------------------------------------------	------



QC

Memo

0.00

Quality Control

11/04/27

(6)

-041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68599

Monday, April 18, 2011 12:29:37 PM



Page 2

Item ID:	D3245-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Access Panel Assembly					
Start Date:	4/18/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	4/25/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>233A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/4/27 SP (6)

11/4/28 JF
mf
11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 12:29:44 PM

Page 1

Work Order ID: 68599

Parent Item: D3245-041

Parent Item Name: Access Panel Assembly

Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

* 2350-18-C3Y



RIGID RECEPTACLE

Purchased

No

110

Each

146.0000

8

48



4/11/04/19

Location

Loc Qty

Loc Code

ST399

46

105729

2

117204*

24

19688

20

ST400

100

117358--

100

23

D3245-1



Panel

Manufactured

No

110

Each

0.0000

1

6



B67547 (6x)

4/11/04/19

* D3245-5



Door

Manufactured

No

110

Each

5.0000

1

6



4/11/04/19

Location

Loc Qty

Loc Code

GA

5

47610

5

5

B68628 (K)

MS20427M3-3



Rivet

Purchased

No

110

Each

1,638.000

16

96



4/11/04/19

Location

Loc Qty

Loc Code

ST318

1638

117206

1638

96

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, April 18, 2011 12:29:44 PM

Page 2

Work Order ID: 68599



Parent Item: D3245-041



Parent Item Name: Access Panel Assembly

Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

MS20615M3-3

Purchased

No

110

Each

200.0000

9

54



Rivet



Handwritten signature and date: 4/18/11

Location

Loc Qty

Loc Code

ST323

200

111650

100

116188

100

54

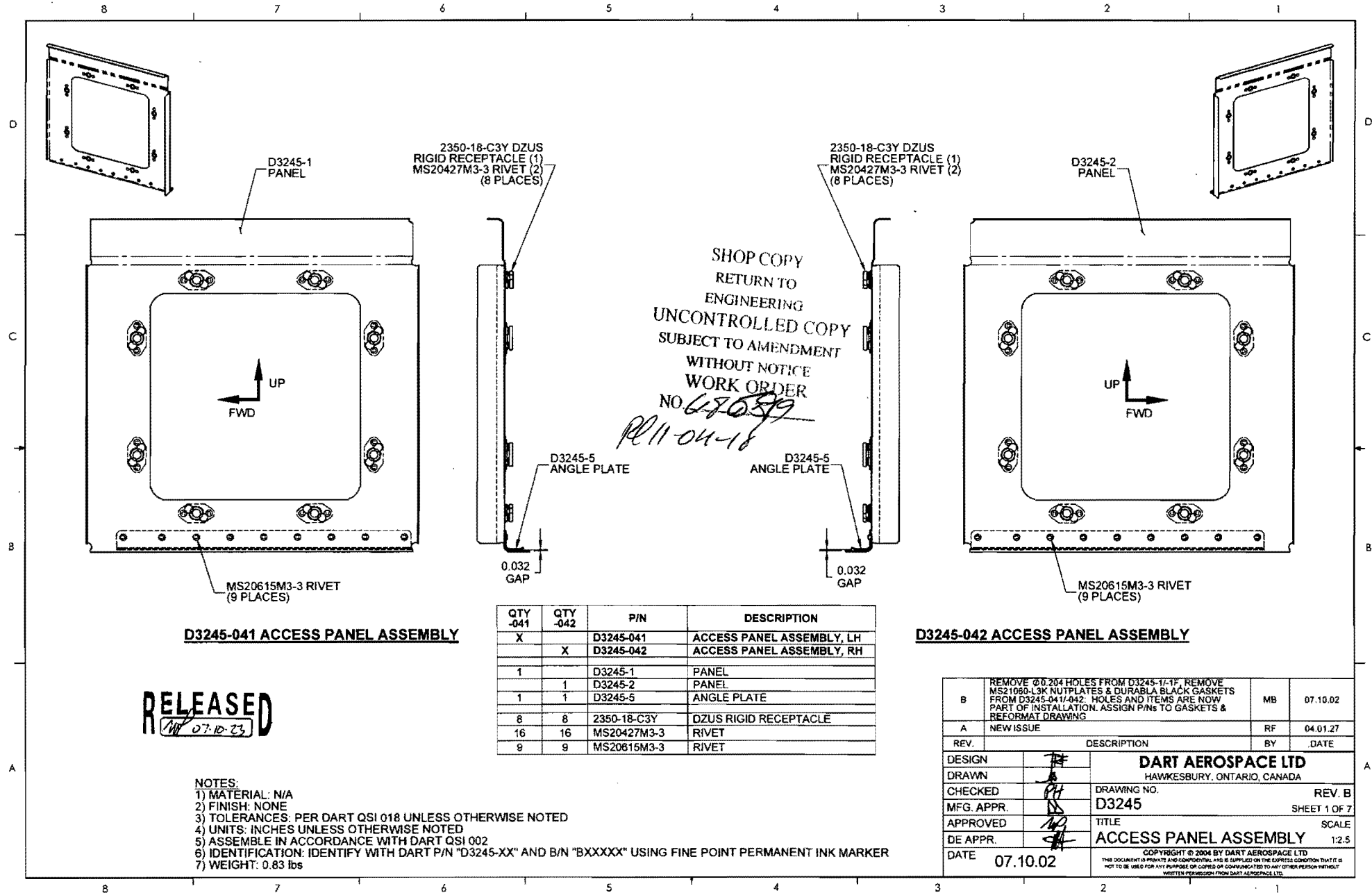
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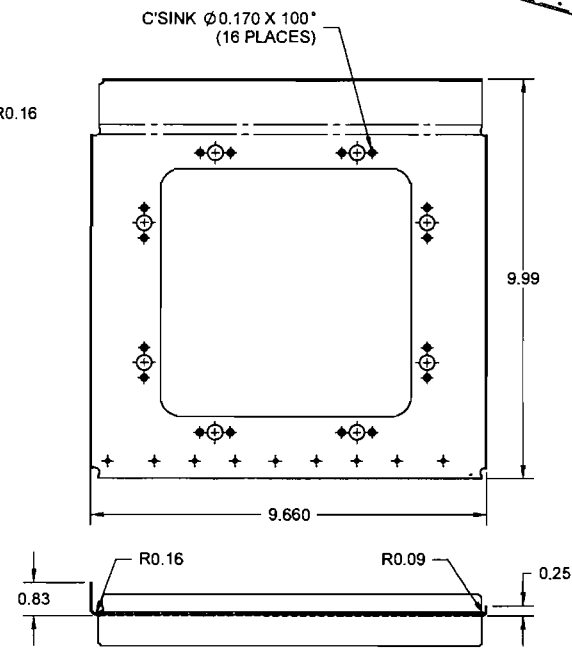
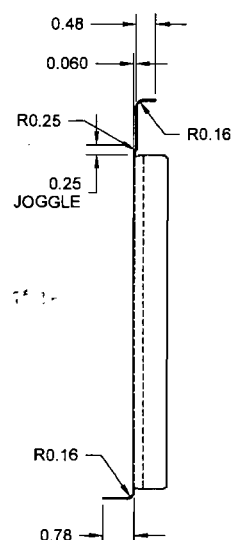
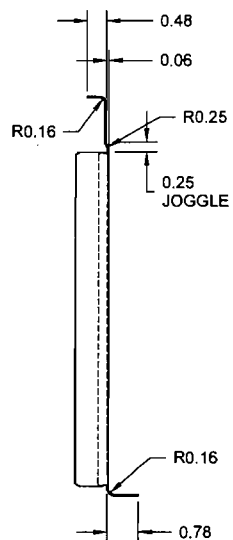
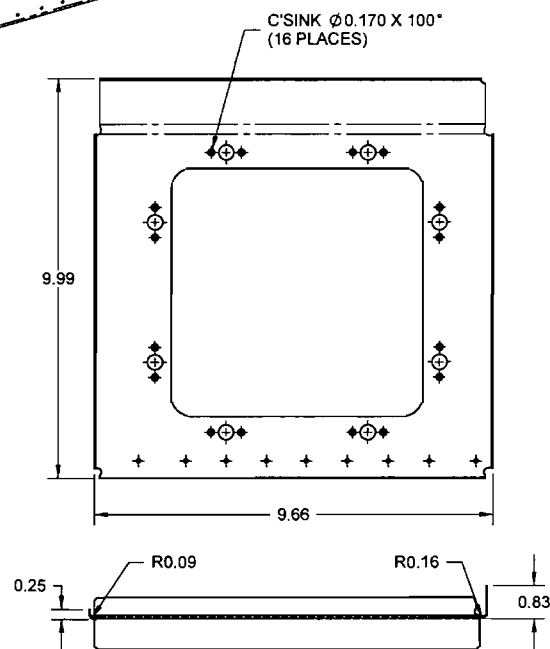
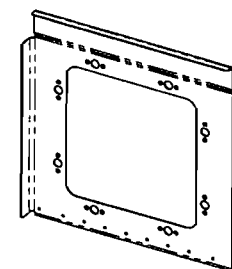
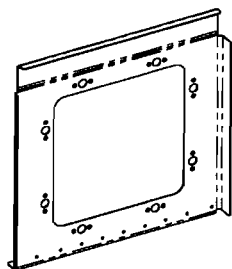
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NOTE: Date & initial all entries



D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED
10-10-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

W1068529

DESIGN	TH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY 1:3	
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

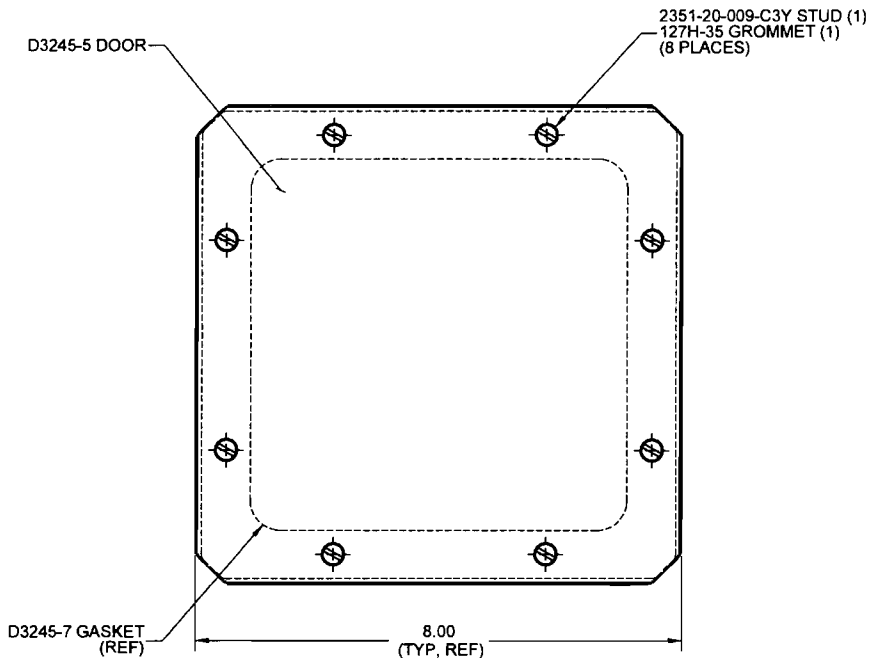
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D

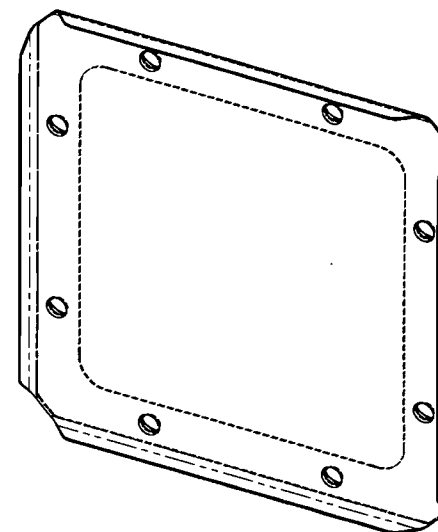
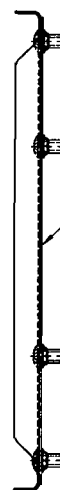
C

B

A



D3245-043 DOOR ASSEMBLY



wlb 68529

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

RELEASED
7/10/02

DESIGN	<i>PH</i>	DART AEROSPACE LTD
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. D3245
MFG. APPR.	<i>PH</i>	REV. B
APPROVED	<i>PH</i>	SHEET 3 OF 7
DE APPR.	<i>PH</i>	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 1:2

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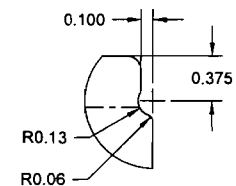
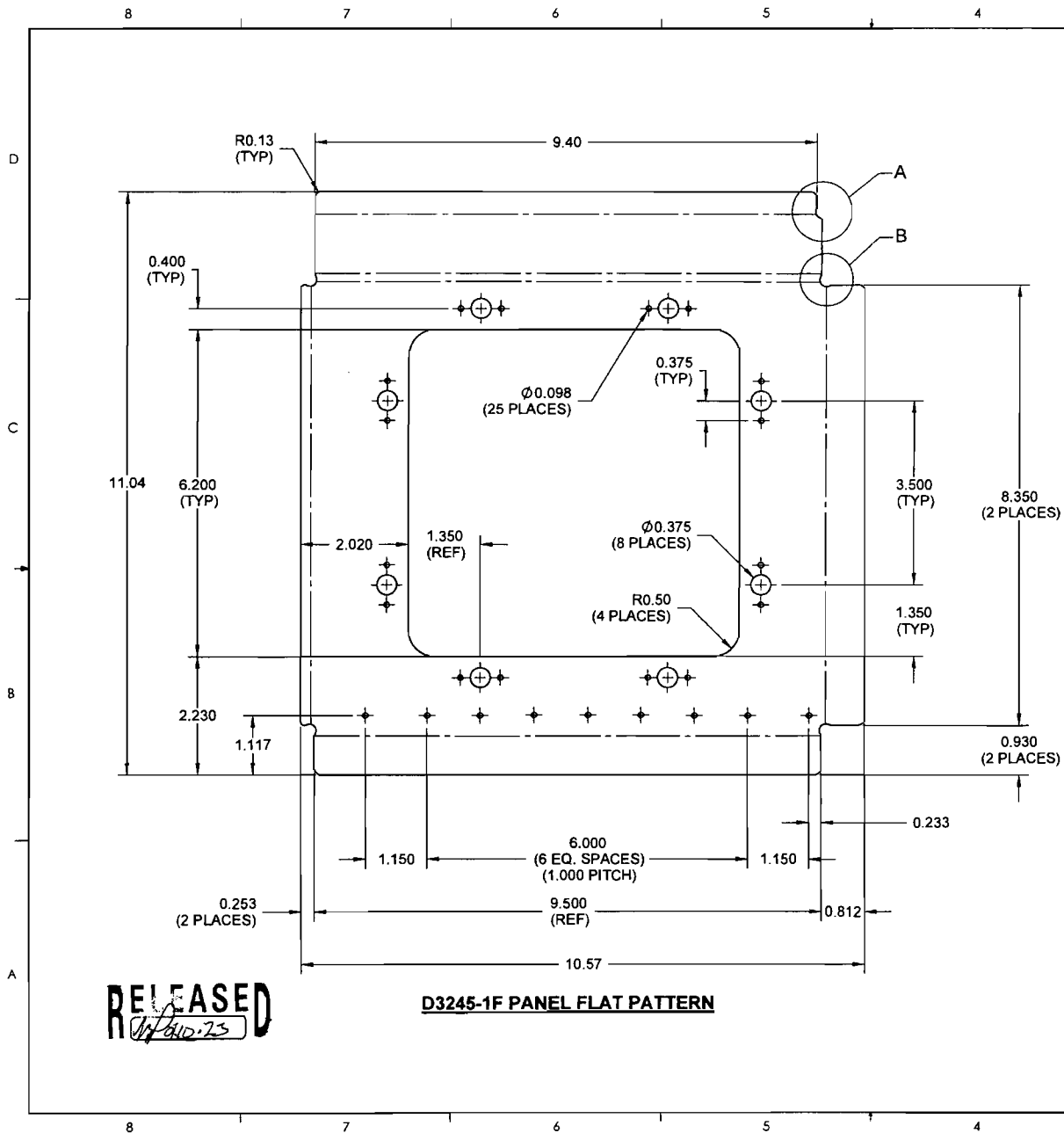
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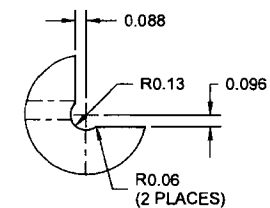
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NOTE: Date & initial all entries



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

W065599

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF: DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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DRAWN	<i>PH</i>	DRAWING NO.	REV. B
CHECKED	<i>PH</i>	D3245	SHEET 4 OF 7
MFG. APPR.	<i>PH</i>	TITLE	SCALE
APPROVED	<i>PH</i>	ACCESS PANEL ASSEMBLY	1:2
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DATE	07.10.02		

RELEASED
W065599

D3245-1F PANEL FLAT PATTERN

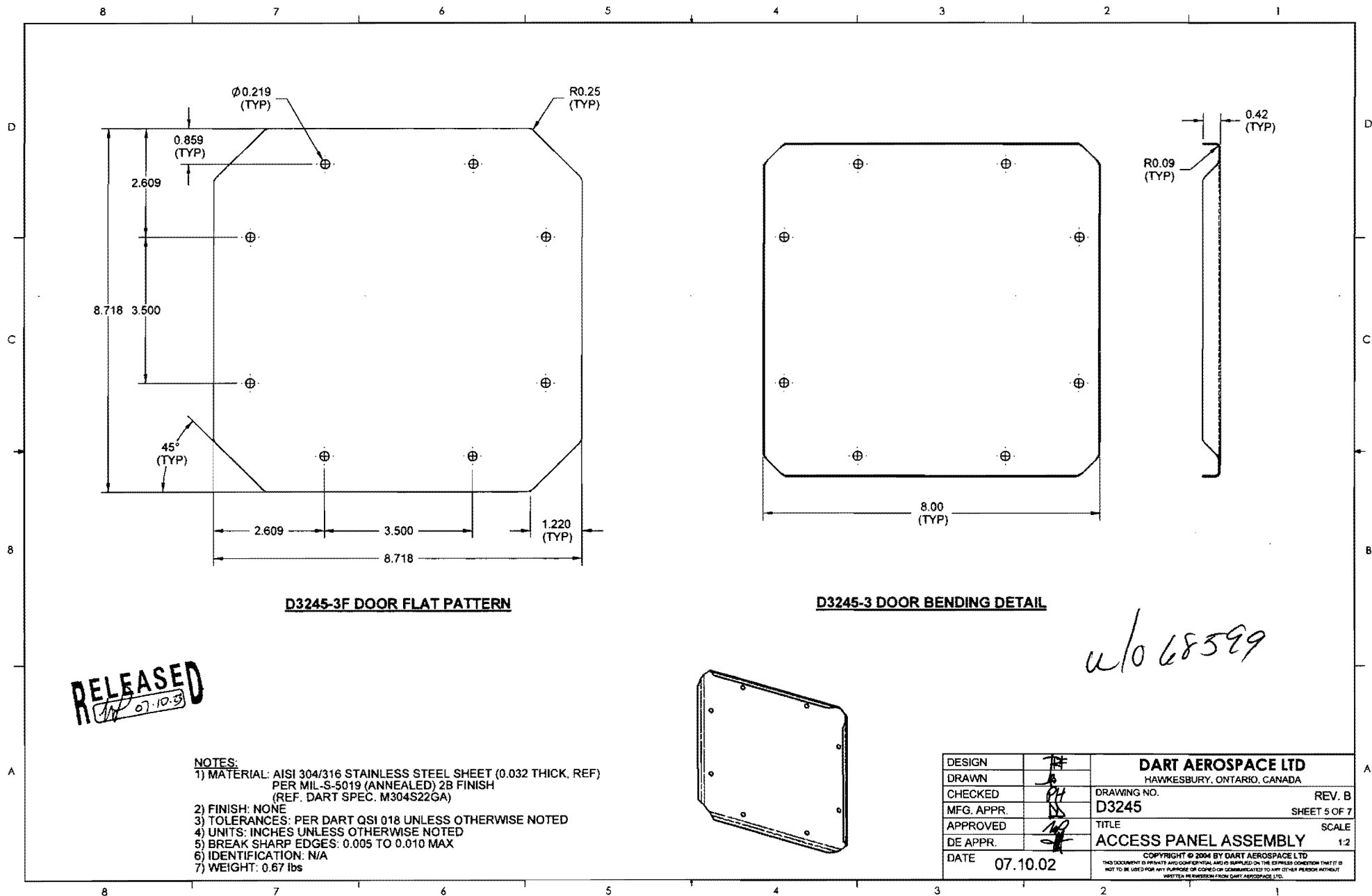
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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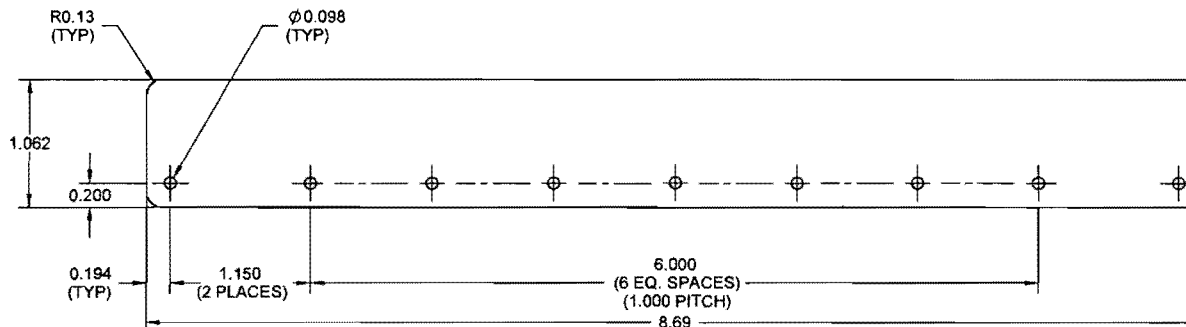
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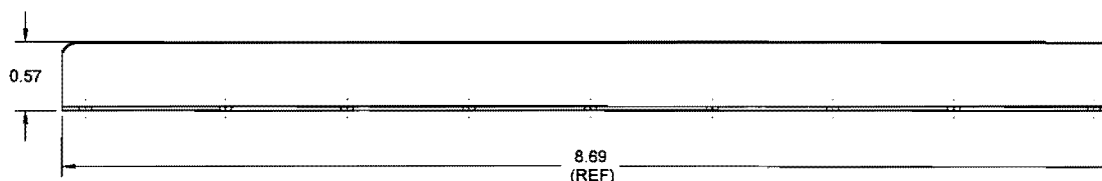
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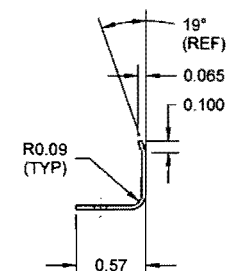
D



D3245-5F FLAT PATTERN



D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)



07/068599

RELEASED
07-10-23

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 6 OF 7
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8 7 6 5 4 3 2 1

A

A

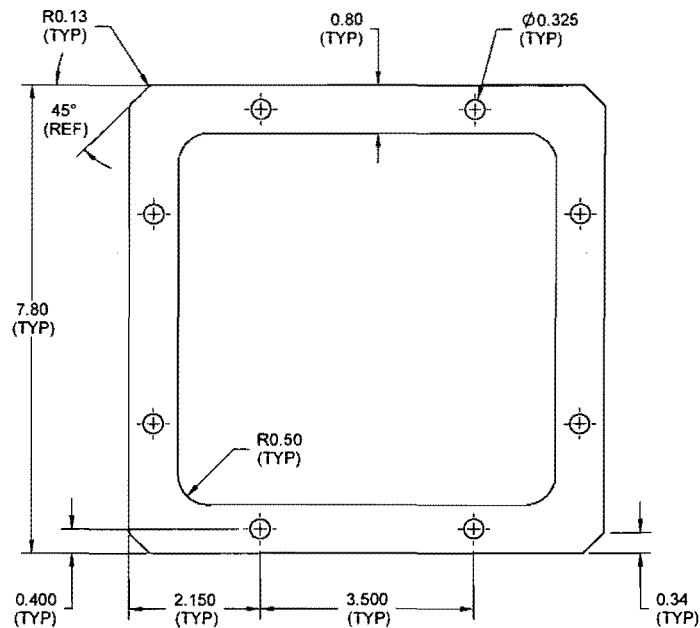
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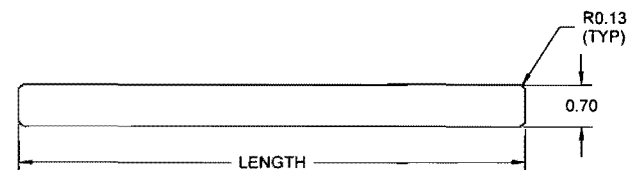
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.02

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

21068599

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CHECKED	<i>PH</i>	DRAWING NO. D3245	REV. B
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